

H/EC

Order ID 113436

113436

Page 1

Item ID: D3322-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pod Assembly

Start Date: 2/7/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/7/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CLDate: 14/02/14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2202

REV G

D3322

Rev A

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 23024

Description:

D2202-1 Pod Lid D2202-5 Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

SHIP TO DELASTEK QTY (1) D3048-1

QTY (3) D3001-1

CL 14/02/14 ①

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Encure certificate of conformity and process sheet from Delastek is attached

14/03/14 ①

Pro

QA Closed: _____ Date: _____

Work Order update only

Work Order: <u>113436</u> Part No. <u>D 3322-041</u> NCR No. <u>14-4269</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☒ Engineering ☐ Quality ☐ Other ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14.12.16	1		PRIMER IS PEELING FROM ALUMINIUM COVER. CH SURFACE WAS NOT CLEANED PROPERLY PRIOR TO APPLICATION OF PRIMER. PL supply 100g.	A.P. 14.12.16	REMOVE NUTS IN AFFECTED AREA. REMOVE PRIMER MECHANICALLY. TOUCH UP ALONG PERQUIS. RE-APPY RE-INSTALL COVER PER DWG.	14/12/18	M/12/18	S 14/12/18
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear		General		Folio/Program		Outside Dimensions		Pressure/Forced	
☐	Bending	☐	Bend	☐	Folio/Program	☐	Outside Dimensions	☐	Pressure/Forced
☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Set-up
☐	Cracks	☐	Broken/Damage/Defect	☐	Hardware	☐	Part Incorrect	☐	Temperature/Cure
☐	Crimp/Kink/Ripple/Wave	☐	Burrs	☐	Inspection Incomplete/Unqualified	☐	Part Lost/Missing	☐	Weld
☐	Cuffs	☐	Contamination	☐	Instructions Incomplete/Unclear	☐	Part Moved	☐	Wrong Stock Pulled
☐	Crushing	☐	Countersink	☐	Misaligned/off center	☐	Positioned Wrong	☐	Other
☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Power Loss/Surge		
☐	Inspection Strip in Tube	☐	Drawing	☐	Micread				
☐	Marks/Chatter	☐	Drill Holes	☐	Off-set				
☐	Turning Sequence	☒	Finish	☐	Out of Calibration				
☐	Wave/Twist in Tube	☐	Fit/Function	☐	Out of Sequence				

113436

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Requ. 3/7/2014 Start Qty: 1.00 *1*
Requ. 3/7/2014 Req'd Qty: 1.00 *1*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Visual inspection. Check for void spot and pins. Check over all dimensions as per Dwg D2202.	0.00 0.00					14/12/18		
130 *130* Small Fab Small Fab	Small Fab SEE ATTACHED <i>14/12/18</i> for details Memo Assemble as per Dwg D2694 & D3322	0.00 0.00					14/12/18		<i>PTO</i>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 14-12-18

145

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 9/10/11 Date: 15/1/13Work Order update only ☐

Work Order: <u>113436</u> Part No. <u>D 3322-041</u> SUPPLIER NCR 14-4267 NCR No. <u>14-4269-15-451</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☒</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☒	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☒	Supplier ☒																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	OC Inspector
Design		14-1/24	170	x1	primer filler is peeling off from aluminum doubler's in base of pod	S 11/12/18 Q2002	re-see all base primer sand down and feather edges of remaining primer re-align exposed aluminum scrub remaining primed surface with scotch brite (to base) re-prime as per QSI 025	ER 14-12/16	DAS 29 9-89 Shi 14/12/18	DAS 29 9-89 S 14/12/12
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier	X									
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Loading Sequence ☐ Lock in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☒ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 113436

November-21-14 2:35:07 PM

113436

Page 3

Item ID: D3322-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pod Assembly
Start Date: 2/07/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/07/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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145

0.00

145

Purchasing

Memo

0.00

Purchasing

ISSUE NEGATIVE PO TO DELASTEK FOR LABOR - \$422.58
REFERENCE NCR14-4269
D2202-3 - B113436 - PO23024 ✓
DELASTEK JOB #60094

CZ 14/12/18

150

Identify as per dwg. & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

RR 113435**DAS
06
9-89**DEC 18 2014

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

15/01/0544-12-19

Picklist Print

Friday, February 14, 2014 7:32:37 AM

Page 1

Work Order ID: 113436

113436

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 2/7/2014

Required Date: 3/7/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD62ABS *AD62ABS* rivet		Purchased	No			130	Each	149.0000	38	38		DAS 27 8-08 M/11/11	

Location	Loc Qty	Loc Code
ST278	149	
125293	7	
m127048	42	
m128211	100	

AD64ABS *AD64ABS* Pop Rivets		Purchased	No			130	Each	146.0000	43	43		DAS 27 8-08 M/11/11	
---	--	-----------	----	--	--	-----	------	----------	----	----	--	------------------------------	--

Location	Loc Qty	Loc Code
ST278	146	
123969	46	
125147	100	

AD66ABS *AD66ABS* Pop Rivet		Purchased	No			130	Each	230.0000	2	2		DAS 27 8-08 M/11/11	
--	--	-----------	----	--	--	-----	------	----------	---	---	--	------------------------------	--

Location	Loc Qty	Loc Code
ST278	230	
112784	230	

AN4-5A *AN4-5A* BOLT		Purchased	No			130	Each	446.0000	19	19		DAS 27 8-08 M/11/11	
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Location	Loc Qty	Loc Code
ST355	446	
120562	346	
m127817	100	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework: ☐ Scrap: ☐ Use-as-is: ☐ Suspected Unapproved: ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Hink/Fipple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, February 14, 2014 7:32:38 AM

Page 2

Work Order ID: 113436

113436

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 2/7/2014

Required Date: 3/7/2014

Start Qty: 1.00

Required Qty: 1.00

AN4-6A Purchased No 130 Each 836.0000 1 1

AN4-6A

BOLT

**

14/2/14

Location

Loc Qty

Loc Code

ST355

47

M126317

47

ST514

789

M126317

539

M127817

250

M128403

AN526C632R7

Purchased No

130

Each

104.0000

2

2

AN526C632R7

Screw

**

14/2/14

Location

Loc Qty

Loc Code

ST345

104

112385

43

117317

61

D2202-1P

Purchased No

110

Each

0.0000

1

1

D2202-1P

Side Pod Lid, 350

**

8p 15-01-5

14/2/14

D2202-5P

Purchased No

110

Each

0.0000

1

1

D2202-5P

Side Pod, Base 350

**

8p 15-01-5

14/2/14

D2204-9

Manufactured No

130

Each

18.0000

5

5

D2204-9

Rubber Latches

**

14/2/14

Location

Loc Qty

Loc Code

st238

18

107654

5

85081

13

B126168

*

Friday, February 14, 2014 7:32:38 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Micread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Gurge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 113436

113436

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 2/7/2014

Required Date: 3/7/2014

Start Qty: 1.00

Required Qty: 1.00

D2429-041

Manufactured No

130 Each 9.0000 1 1

D2429-041

Spring Clip Ass'y

**

698
27
9.00
11/11/11

Location

Loc Qty

Loc Code

ST010

9

107532

6

81895

3

D2462

Manufactured No

130 f 202.2300 14.17 15

D2462

Seal \$Per Foot

**

698
27
9.00
11/11/11

Location

Loc Qty

Loc Code

ST402

202.23

98802

202.23

D2528-1

Manufactured No

130 Each 10.0000 5 5

D2528-1

Backer Plate

**

DAG
27
9.00
11/11/11

Location

Loc Qty

Loc Code

ST011

10

82334

10

D2528-3

Manufactured No

130 Each 4.0000 4 4

D2528-3

Backer Plate

**

DAG
27
9.00
11/11/11

Location

Loc Qty

Loc Code

ST011

4

107611

2

65085

2

D2569

Manufactured No

130 Each 0.0000 1 1

D2569

Hinge

**

DAG
27
9.00
11/11/11

B110812

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework: ☐ Scrap: ☐ Use-as-is: ☐ Suspected Unapproved: ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Fink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 4

Work Order ID: 113436

113436

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 2/7/2014

Required Date: 3/7/2014

Start Qty: 1.00

Required Qty: 1.00

D3001-1 Manufactured No

110 Each 2.0000 3 3

D3001-1

Doubler

**

CL 14/02/18

Location

Loc Qty

Loc Code

ST178

2

107795

2

D3007-041 Manufactured No

130 Each 2.0000 1

D3007-041

Prop Assy

**

1,599,490 (1,599,490) - 1,599,490

1,599,490

DAS

27

8-00

Location

Loc Qty

Loc Code

ST259

2

107599

1

84300

1

D3048-1 Manufactured No

110 Each 1.0000 1 1

D3048-1

Doubler

**

CL 14/02/18 ①

Location

Loc Qty

Loc Code

CA

1

107527

1

MS21042L06 Purchased No

100 Each 325.0000 2 2

MS21042L 06

Nut

**

Blocks & R

DAS

27

8-00

Location

Loc Qty

Loc Code

ST314

325

m127304

125

m127831

200

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crutching ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
---	--	---	--

Picklist Print

Friday, February 14, 2014 7:32:38 AM

Page 5

Work Order ID: 113436

113436

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 2/7/2014

Required Date: 3/5/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

130

Each

3,583.000

20

20

MS21042L4******

Locknut

LocationLoc QtyLoc Code

GA

48

m126333

48

ST509

3524

m127255

1524

m127813

2000

ST518

11

m127376

11

m1274134

20

DAS

27

0.00

NAS1149D0463J

Purchased

No

130

Each

5,937.000

21

21

NAS1149D0463J******

WASHER

LocationLoc QtyLoc Code

ST294

1537

M127693

1537

ST510a

4400

M127813

1400

M127904

3000

m128995

21

DAS

27

0.00

NAS1149DN632J

Purchased

No

130

Each

270.0000

2

2

NAS1149DN632J******

Washer

LocationLoc QtyLoc Code

ST293

278

M126084

178

M127255

100

m128812

2

Friday, February 14, 2014 7:32:38 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Hink/Ripple/Wave ☐ Cuffs ☐ Cruching ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/5316,
OR DEPAKANE 470-33/411/510A-10

FOAM: A500 CORE CELL,
OR DIVINYCELL,
OR AIREX,
0.33 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7701 WEAVE "S" GLASS (9 oz SATIN)
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005-4.2
OUTSIDE = WHITE GELCOAT GEL 94-W005

3) TOLERANCES: PER DART QSI 013 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 003.
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

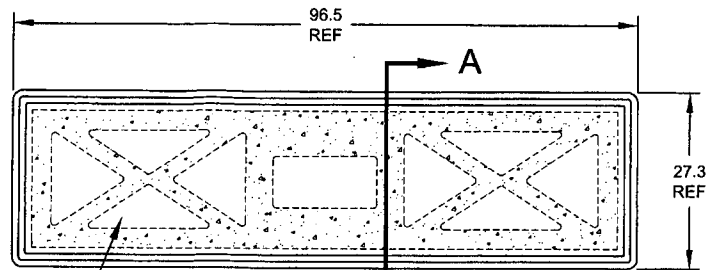
CL1462/14
W10: 113436

RELEASED
2010-10-28

G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-3); ADD 77.5 & 22.0 DIM. (ZH D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZH D3-1); INCORPORATED DEC 9317.5 ADD D2202-5/6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	90.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	PF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	47	TITLE	SCALE
DE APPR.	47	UTILITY/POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DRAWING OR ANY INFORMATION CONTAINED HEREIN MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

SEE
DETAIL B
A6-2

SECTION A-A C3-2

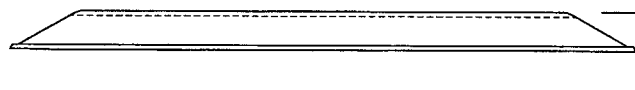


G

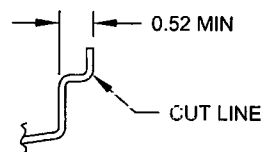
D2202-101 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER REF. DT8003

A C6-2

6.0 REF



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 10X D6-2

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-101 FOAM CORE
5oz KEVLAR
9oz SATIN

G

RELEASED
R 2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	117	TITLE	SCALE
DE APPR.	117	UTILITY / POD LID AND BASE	HTS
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8 7 6 5 4 3 2 1

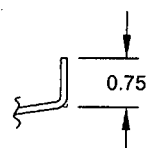
D
C
B
A

D
C
B
A

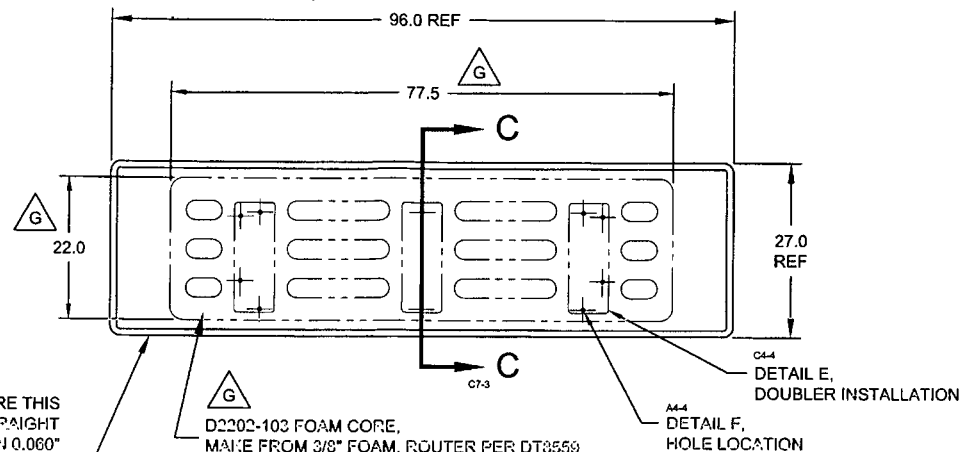
SEE
DETAIL D
B7-3

SECTION C-C C4-3

ENSURE THIS
EDGE IS STRAIGHT
WITHIN 0.060"
AFTER TRIMMING



DETAIL D
SCALE 10X
D7-3



D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

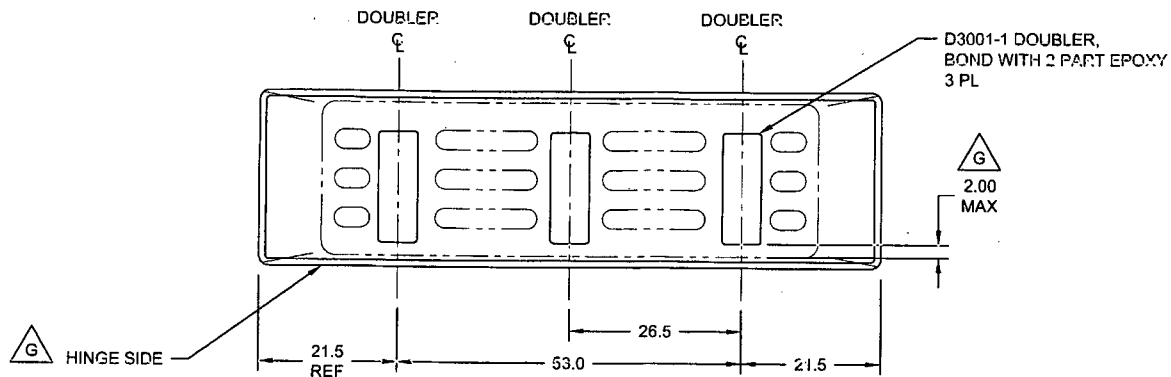
9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-103 FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN



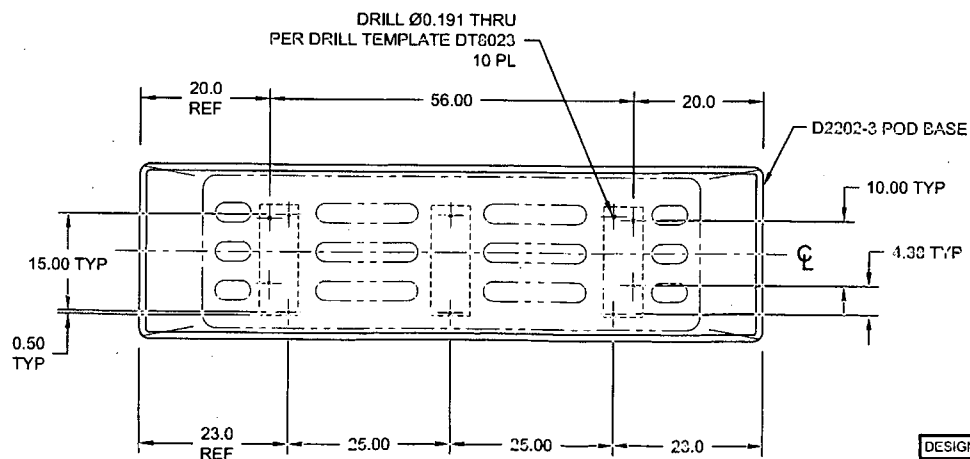
RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD			
DRAWN	PF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PF	DRAWING NO.	REV. G		
MFG. APPR.	JM	D2202	SHEET 3 OF 5		
APPROVED		TITLE	SCALE		
DE APPR.		UTILITY POD LID AND BASE	NTS		
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD			
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8 7 6 5 4 3 2 1



DETAIL E: INSTALLATION OF D3001-1 DOUBLERS C3-3



DETAIL F: HOLE DRILLING C3-3
(AFTER DOUBLER INSTALLATION)

RELEASED
R 2010-10-28

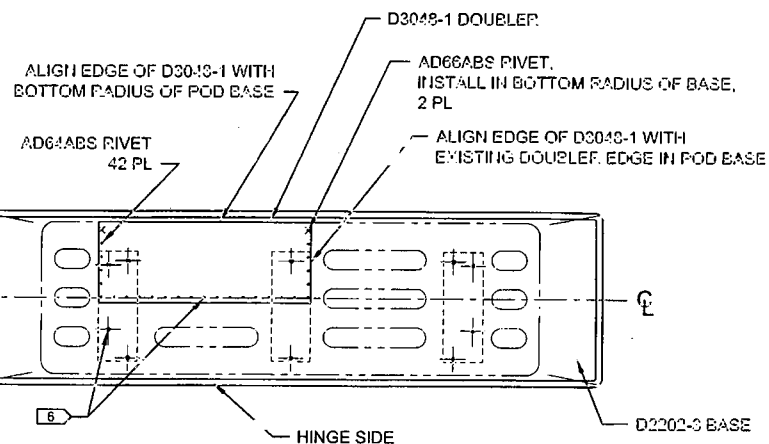
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	HTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED BY THE NATIONAL ARCHIVES OF CANADA NOT TO BE USED IN ANY MANNER THAT WOULD BE DETRIMENTAL TO THE NATIONAL DEFENCE NOT TO BE USED IN ANY MANNER THAT WOULD BE DETRIMENTAL TO THE NATIONAL DEFENCE	

NOTES: TO MAKE A D2202-5/6 BASE (FOR D3048-1 DOUBLER) FROM A D2202-3 BASE

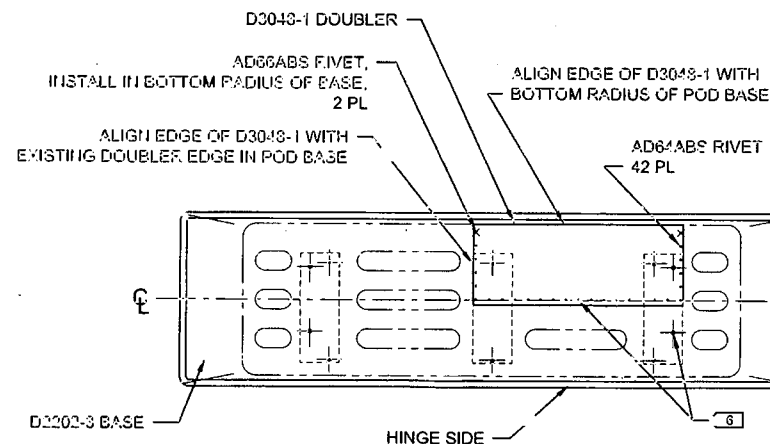
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 80:20 SATIN AND RESIN PER DWG (APPROX 3-4 LAYERS)
- 3) 2 LAYERS OF 90:10 SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER CO.125 HOLES FROM D3048-1 TO POD BASE.
INSTALL DOUBLER WITH AD66ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER CO.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

PART LIST:

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
Y		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD66ABS	RIVET
2	2	AD66ABS	RIVET
NR	NR	RTV	SEALANT



D2202-5 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)



D2202-6 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	PF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	100	TITLE	SCALE
DE APPR.	100	UTILITY POD LID AND BASE	ITS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	



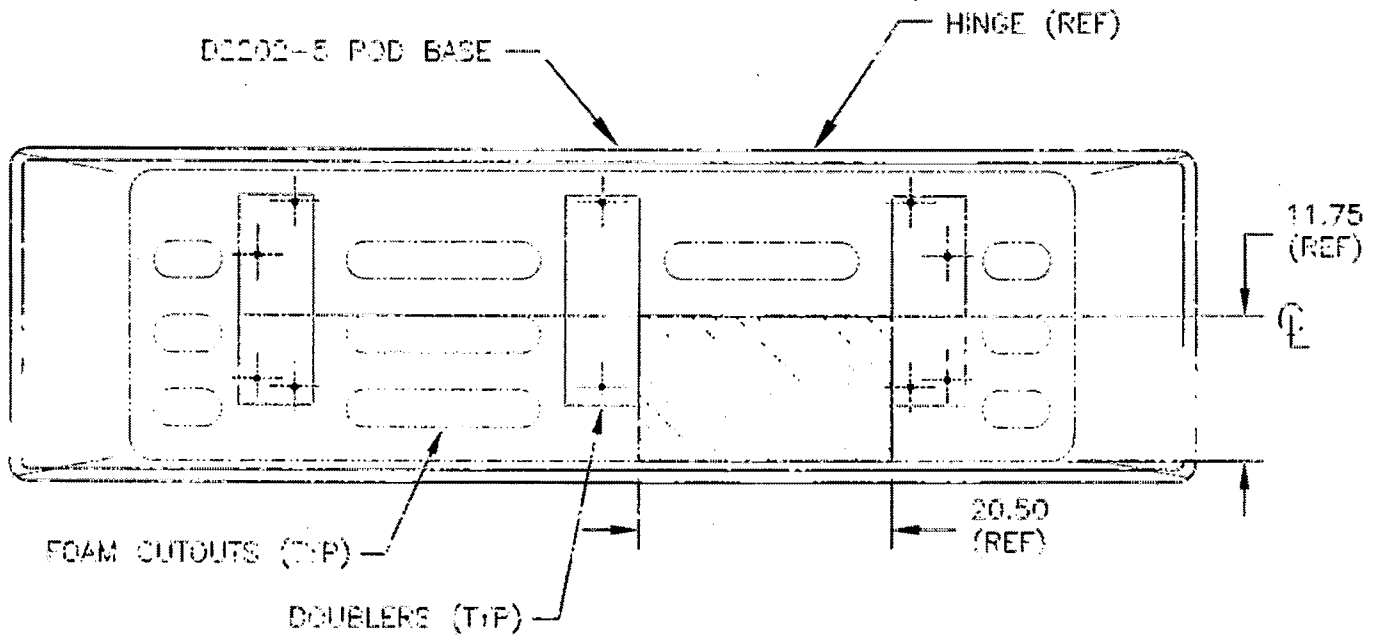
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3322	SHEET 1 OF 1
DATE 04.09.06		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.06	NEW ISSUE	

RELEASED
24.10.79

C214102114
W10: 113436

D3322-041/-042 POD ASSEMBLY

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE



D3322-041 POD ASSEMBLY (SHOWN)
D3322-042 POD ASSEMBLY (OPPOSITE)

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO23024**

Purchase Order Date 2/14/2014

PO Print Date 2/14/2014

Page Number 1 of 2

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
2/14/2014

Contact Name

Vendor Phone 319 533 5783

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FOA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2991-2P AS PER DWG D2991 REV. E B113434	Side Door	3/14/2014 Yes 3/14/2014	1.00 Each	\$320.00	\$320.00
Line Total:						\$820.00
2	D2202-1P AS PER DWG D2202 REV. G B113436	Side Pod Lid, 350	3/14/2014 Yes 3/14/2014	1.00 Each	\$2,890.60	\$2,890.60
Line Total:						\$2,890.60
3	D2202-5P AS PER DWG D2202 REV. G B113436	Side Pod, Base 350	3/14/2014 Yes 3/14/2014	1.00 Each	\$2,890.60	\$2,890.60

PO Instructions: Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A016 personnel qualification
A025 certification of conformance
A040 notification of quality escape
A041 quality management
A042 dari notification by supplier

Note:



DELASTEK Inc.
2699 5^e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	56854
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawthornbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200 EXT 236
Contact : Alba Panzuto

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawthornbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577
Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
31-03-2014	14-02-2014	24354	Chantal Lavoie	PO23024	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Marie-Pier Montambeault, 235			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073	Line #2 D2202-1 Side Pod Lid E113436 Référence DKA362-0015 DWG: REV. G Lot # 59756	U of M: Chaque 1
1	0	1	DKC134-0075	Line #3 D2202-5 Side Pod Base E113436 DWG: D2202 Rév.: G Lot # 60094	U of M: Chaque 1

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:



Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2014-02-18 09:51:17
 Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD LID
Numéro Job	: 59756	Numéro Article	: DKC124-0073
Numéro	: 4347	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2014-02-18 No. :	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - - Type :	Date Dûe	: 2014-02-25 Qté: 1 Ud UNITE
Job précédente	: 59761		
Écrit par	: _____		
Vérifié & Approuvé par	: _____		
Commentaires	: N° de Pièce Client: D2202-1		



COPIE

Process Sheet Rév.: 03 Ajout de la IF134-0003 à la
 séquence 35.0.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 53634, Frakote Loctite Wolo
-----	---------	--------------------------------

Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
 N° 53634, Frakote Loctite Wolo # de Lot: 1-4229-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 28/02/14 Socau: _____



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total: 1.250 KILOGRAMME(s)
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-44240-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)
 Catalyst N° DDM-9 N° de Lot: 1-2829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le gel coat selon IG 0019.

Date: 28/02/14 Socau: _____



Date: Mardi, 2014-02-18 09:51:17

Utilisateur: marc dubé

Feuille de Procédé

Client: DAPT US DAPT AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 59756

Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 9.90 VERGE(s)/Unit Total: 9.90 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

7.0 AAC1885

Tissu à délaminer Release ply B

Comment Qty.: 9.16 VERGE(s)/Unit Total: 9.16 VERGE(s)
Tissu à délaminer Release ply B

de Lot: N/A

8.0 AAC1608

5oz plain weave Kevlar 50" wide roll

Comment Qty.: 6.60 VERGE(s)/Unit Total: 6.60 VERGE(s)
5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-42765-1

9.0 AAC1887

Wrightlon 5200 Bleu P3

Comment Qty.: 14.95 VERGE(s)/Unit Total: 14.95 VERGE(s)
Wrightlon 5200 Bleu P3

de Lot: N/A

10.0 AC0885

Feutre de drainage N° Airweave N 10

Comment Qty.: 12.50 VERGE(s)/Unit Total: 12.50 VERGE(s)

11.0 AC0943

Stretchlon 200 poche à vide Vert

Comment Qty.: 42.63 PIED(s)/Unit Total: 42.63 PIED(s)

12.0 AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total: 3.0000 ROULEAU(s)

13.0 TAILLAGE

Faire le taillage du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les côtés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply

Film Durisol P-3

Feutre de drainage 6m

Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Date: Mardi, 2014-02-19 09:51:17

Utilisateur: marc dubé

Feuille de Procédé

Client: DAPT US DAPT AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 59756

Numero DKC134-0073

Numéro Job:



Séq.: Machine ou Opération:

Description :

Date: 20/02/14

Sceau:



14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-44762-1

15.0 AMB0236

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22829-1

16.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid :
1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Date: 28/02/14

Sceau:



17.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Hevlar)
de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350
Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre
avec les deux extrémités et terminer avec les deux côtés. (Ajouter de la résine au besoin
)

Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Hevlar)

Date: 28/02/14

Sceau:



18.0 BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher 4 heures minimum

Date: 28/02/14

Sceau:



Date: Mardi, 2014-02-13 09:51:17
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 59756

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

19.0 AMB0312 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-44782-1

20.0 AMB0396 Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total: 0.0135 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 DKC134-0022 D2202-101 Foam Core (Utility Pod Lid)

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
D2202-101 Foam Core (Utility Pod Lid) N° de Job: 59761

22.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst
DDM-9 par quantité de résine.

Date: 27/02/14 Soeau:



23.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0022 selon IG 0105.

Date: 27/02/14 Soeau:



24.0 AAC1611 Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)
Polybond B46F N° de Lot: 1-38899-1

25.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG
0033.

Date: 3/03/14 Soeau:



26.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Date: Mardi, 2014-02-18 09:51:17

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 59756

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing:

8:30

Heure Fin Curing:

9:50

Date:

3/03/14

Sceau:



27.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment

Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-44782-1

28.0

AMB0286

Catalyst N° DDM-9

Comment

Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

29.0

PREP-GENERAL

Préparation du matériel



Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod
Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

Date:

4/03/14

Sceau:



30.0

LAMINAGE

Faire le laminage



Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux côtés. (Ajouter de la résine au besoin)

Recommencer pour le dernier plis. (un pli de 9 oz)

Date:

4/03/14

Sceau:



Feuille de Procédé

Client: DART US DART AÉROSPACE	Nom Dessin: UTILITY POD LID	
Numéro Job: 59756	Numéro: DKC134-0073	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
31.0	BAGGING	Faire le bagging sur la pièce
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012. Laisser sécher 4 heures minimum. Heure début Curing: <u>1:15</u> Heure Fin Curing: <u>8:00</u> Date: <u>4/03/14</u> Soeau:  		
32.0	DÉMOULAGE	Démoulage de la pièce
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la pièce Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis. Date: <u>5/03/14</u> Soeau:  		
33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-44559-2</u>		
34.0	FINITION	Finition Générale
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120. Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air. Corriger les imperfection de surface à l'aide du "Filler" P15-3 selon IG 0043 Laisser sécher jusqu'au lendemain Date: <u>6/03/14</u> Soeau:  		

Date: Mardi, 2014-02-18 09:51:17
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: UTILITY POD LID	
Numéro Job: 59756	Numéro: DKC134-0073	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
35.0	TRIMAGE	Trimage
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le trimage du Pod Lid selon la IF134-0003. Date: <u>5/03/12</u> Socau:  		
36.0	AAC1021	Dupont Primer N° 7704S
Comment Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-44324-1</u>		
27.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44995-1</u>		
38.0	PRIMER	Application primer
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008 Date: <u>06/03/14</u> Socau:  # Fiche de Mélange: <u>6563</u>		
39.0	FINITION	Finition Générale
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes. Date: <u>07/03/14</u> Socau:  		
40.0	AAC1021	Dupont Primer N° 7704S
Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43946-3</u>		
41.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44895-1</u>		
42.0	PRIMER	Application primer
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008 Date: <u>10/03/14</u> Socau:  # Fiche de Mélange: <u>6563</u>		

Date: Mardi, 2014-02-18 09:51:17
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 59756

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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43.0	INSPÉC FINAL	Inspection finale
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 26 mars 14 Soeau:



Interieur



26 mars 14

44.0	EMBAL / ENTREPO	Emballage & Entreposage
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: Soeau:

Date: Lundi, 2014-03-03 08:54:15
 Utilisateur: Véronique Bouchard

Feuille de Procédé

Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD BASE
Numéro Job	: 60094	Numéro Article	: DKC134-0075
Numéro	: 4345	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2014-03-03 No. :	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - - Type :	Date Due	: 2014-03-10 Qté: 1 Ud UNITE
Job précédente	: 59757		

Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de Pièces Client: D2202-5

Process Sheet Rév.: 02 AAC1085 était AC0083,
AAC1087 était AC0884



COPIE

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
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1.0	AAC1616	N° 83634, Frekote Locite Wolo
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Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
 N° 83634, Frekote Locite Wolo # de Lot: N/A

2.0	PREP-GENERAL	Préparation du matériel
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKC-0331 selon IF134-0011.

 Date: 5/03/14 Soeau: _____


3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
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Comment Qty.: 1.250 FILOISFAMME(s)/Unit Total: 1.250 FILOISFAMME(s)
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-44240-1

4.0	AMB0206	Catalyst N° DDM-9
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Comment Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)
 Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	GEL COAT	Application du Gel Coat
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le Gel Coat sur le moule selon IF134-0011.

 Date: 5/03/14 Soeau: _____


Date: Lundi, 2014-03-03 08:54:15

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 60094

Numéro DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 9.90 VERGE(s)/Unit Total: 9.90 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

7.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 9.16 VERGE(s)/Unit Total: 9.16 VERGE(s)

Tissu à délaminer Release ply B

de Lot: N/A

8.0 AAC1608 5oz plain weave Kevlar 50" wide roll

Comment Qty.: 6.60 VERGE(s)/Unit Total: 6.60 VERGE(s)

5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-42765-1

9.0 AAC1887 Wrighton 5200 Bleu P3

Comment Qty.: 14.95 VERGE(s)/Unit Total: 14.95 VERGE(s)

Wrighton 5200 Bleu P3

de Lot: N/A

10.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 12.50 VERGE(s)/Unit Total: 12.50 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 42.63 PIED(s)/Unit Total: 42.63 PIED(s)

12.0 AC0806 Ruban à gommer jaune #: TAT-200Y

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total: 3.0000 ROULEAU(s)

13.0 AC1091 Film durisol # 3001792

Comment Qty.: 12.50 METRE CAR(s)/Unit Total: 12.50 METRE CAR(s)

14.0 TAILLAGE Faire le taillage du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le taillage du matériel et le matériel pour le Bagging selon IF 134-0011.

Date: 3-03-14 Soeau:



15.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 FILOGRAMME(s)/Unit Total: 2.500 FILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-44782-1

16.0 AMB0296 Catalyst N° DDM-9

Comment Qty.: 0.0245 GALLON(s)/Unit Total: 0.0245 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

17.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le laminage des tissus (verre et Kevlar) selon IF134-0011.

Date: 5/03/14 Soeau:



Date: Lundi, 2014-03-03 08:54:15

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 60094Nom Dessin: UTILITY POD BASE
Numéro: DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 12:45

Heure Fin Curing: 8:00

Date: 5/03/14

Sceau:



19.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-44782-1

20.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total: 0.0135 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0

DKC134-0021

D2202-103 Foam Core (Utility pod Base)

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
D2202-103 Foam Core (Utility pod Base)

N° de Job: 60095

22.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Sceller le Foam Core N° DKC134-0021 selon IG 0105.

Date: 5/03/14

Sceau:



23.0

AAC1611

Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)
Polybond B46F N° de Lot: 1-38189-1

24.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011.

Date: 6/03/14

Sceau:



Date: Lundi, 2014-03-03 08:54:15

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 60094

Numéro DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

25.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:20

Heure Fin Curing: 11:40

Date: 6/03/14

Socau:



26.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la découpe manuelle du foamcore selon IF134-0011 point 8.5.

Date: 6/03/14

Socau:



27.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 FILOGFAMME(s)/Unit Total: 2.500 FILOGFAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-45028-1

28.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

29.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des derniers tissus selon IF134-0011.

Date: 11/03/14

Socau:

4297A.M.



30.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 12:30

Heure Fin Curing: 8:00

Date: Lundi, 2014-03-03 08:54:15

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 60094

Numéro DKO134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 11/03/14

Sceau: 4297 A.M.



31.0

AAC1615

D3001-1 Doubler (Pod Base D2002-3)

Comment Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)

D3001-1 Doubler (Pod Base D2002-3)

N° de Lot: 1-44313-1

32.0

AAC0102

Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.50 UNITE(s)/Unit Total: 0.50 UNITE(s)

Colle Araldite N° 2012 (50ml)

N° de Lot: 1-44566-1

33.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller les trois doubler N° D3001-1 selon IF134-0011.

Faire trois petites poches à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 3:30

Heure Fin Curing: 8:00

Date: 18/03/14

Sceau:



34.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.030 GALLON(s)/Unit Total: 0.030 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 2-45000-2

35.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Retirer les trois poches à vide et faire un joint tout autour des trois doubler à l'aide du "Filler" P15-3 et laisser sécher.

Date: 19/03/14

Sceau:



36.0

AAC1630

D3048-1 Doubler

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

D3048-1 Doubler

N° de Lot: 1-44313-2

37.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.

Date: Lundi, 2014-03-03 08:54:15
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: UTILITY POD BASE	
Numéro Job: 60094	Numéro DKC134-0075	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
Date: 19/03/14 Soeau:  		
38.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment	Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 2-45000-2	
39.0	FINITION	Finition Générale
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la finition de l'intérieur selon IG 0043. Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine aux endroits où il y a des bulles d'air. Corriger les imperfections de surface à l'aide du "Filler" P15-3. Laisser sécher jusqu'au lendemain. Date: 21-03-14 Soeau:  	
40.0	DÉMOULAGE	Démoulage de la pièce
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce. Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis. Date: 20/03/14 Soeau:  	
41.0	TRIMAGE	Trimage
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le trimage selon IF134-0012. Date: 20/03/14 Soeau:  	

Date: Lundi, 2014-03-03 08:54:15

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 60094

Numéro DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

42.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-44224-1

43.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0253 UNITE(s)/Unit Total : 0.0253 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44063-3

44.0 PRÉPARATION. Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date: 24/03/14 Soeaur:



45.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 24/03/14 Soeaur:



de Fiche technique: 6572

46.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Poncer le "Primer" batisseur selon IG 0008.

Date: 25/03/14 Soeaur:



47.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-34946-3

48.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0253 UNITE(s)/Unit Total : 0.0253 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44063-3

49.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 26/03/14 Soeaur:



Date: Lundi, 2014-03-03 08:54:15
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DAPT US DAPT AEROSPACE
Numéro Job: 60094

Nom Dessin: UTILITY POD BASE
Numéro DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

50.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 27/03/14

Sceau:



51.0 EMBAL / ENTREPO Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date: Sceau:



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Wednesday, November 12, 2014

Raised Date 11/12/2014	Status Open	Owner Lavoie, Chantal	Number NCR14-1269
Target Date 11/28/2014	Standard		Severity MAJOR
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Delaetec Inc		Fault Category Supplier
Details found during prep work (cleaning) of D3322-041 B113436 pod assembly purchased on PO#23024 that the pod (D3322-041) has the primer flaking off in large chunks. it appears that the pod was not properly cleaned before the primer base was applied. see attached pictures <i>base for</i>			
Keywords		Product D3322-041	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Target Date 11/27/2014	Owner Downing, Eric M	Closed Date	Closed By
Details			

Number	Owner	Target Date	Completed Date
Details	Response		
2	Lavoie, Chantal	11/21/2014	
contact supplier to obtain a corrective action and a root cause. inform supplier of two types of actions that can be taken here at Dart: 1- send the pod back to them (will need a RMA#) 2- Most critical areas of the pod that is not working and apply paint strip. 1-11-10 use alcohol to clean materials. 1-11-10 use scotch brite then scuff the entire inside surface of the pod with red scotch brite and reapply the primer as per QSI005 (supplier should be billed for repair work done here @ Dart)		<i>remove all loose paint, feather hand paint edge (blend) re-align any exposed aluminum</i> <i>scotch brite the top of pod + re-prime also to ensure a smooth finish</i>	
3	Downing, Eric M	11/21/2014	
reinspect inside finish of pod			

Target Date 11/27/2014	Owner Smith, Patrick	Closed Date	Closed By
Details			

Number	Owner	Target Date	Completed Date
Details		Response	

Linda Lacelle

From: Melody Shapcott <MShapcott@delastek.com>
Sent: November-20-14 9:32 AM
To: Linda Lacelle
Cc: Jocelyne Laurin
Subject: RE: pics of flaking paint from pod

Hello Linda,
Please proceed with the repair at Dart's facility.

Thank you,

Melody Shapcott
Gestionnaire de comptes

DELASTEK Inc.
2699, 5e Avenue, Local 14
Grand-Mère, Québec
G9T 2P7
Tel : 819-533-5788 #235
Fax : 819-533-3494
mshapcott@delastek.com

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Devez-vous vraiment imprimer ce courriel ? Pensons à l'environnement ! / Please consider the environment before printing this email

-----Message d'origine-----

De : Linda Lacelle [<mailto:llacelle@dartaero.com>] Envoyé : 20 novembre 2014 08:12 À : Melody Shapcott Objet : RE: pics of flaking paint from pod

Hi Melody,

-----Message d'origine-----

De : Linda Lacelle (<mailto:llacelle@dartaero.com>) Envoyé : 12 novembre 2014 08:33 À : Jocelyne Laurin; Melody Shapcott Objet : FW: pics of flaking paint from pod

-----Original Message-----

From: Linda Lacelle

Sent: November-12-14 8:30 AM

To: 'Jocelyne Laurin (jlaurin@delastek.com)'; Melody Shapcott (MShapcott@delastek.com)

Subject: FW: pics of flaking paint from pod

Good Morning,

We took this pod out of stk and was about to assemble. As you see the primer is flaking off a lot! Please advise how you would like to proceed. We can repair here and charge Delastek the labor, or we can send it back for you to repair.

Thanks

Linda

-----Original Message-----

From: Eric Downing

Sent: November-12-14 8:15 AM

To: Linda Lacelle; Chantal Lavoie

Cc: Patrick Smith; Patrick Duval

Subject: pics of flaking paint from pod

Linda / Chantal

Here is the pictures of the flaking paint on the utility pod that is currently being worked on. Please preform the actions on the NCR.

Thanks

With Kind Regards

Eric Downing

QA Coordinator

T: 1-613-632-5200 ext 223

C:1-613-363-9375

F: 1-613-632-5246

www.dartaero.com

Edowning@Dartaero.com

-----Original Message-----

From: Eric Downing

Sent: Wednesday, November 12, 2014 7:43 AM

To: Eric Downing

Subject:



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: March 27, 2015

Raised Date 12/11/2014	Status Closed	Owner Lavoie, Chantal	Number NCR14-4269
Target Date 16/01/2015	Standard		Severity MAJOR
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Delastek Inc		Fault Category Supplier
Details found during prep work (cleaning) of D3322-041 B113436 pod assembly purchased on PO#23024 that the lid (D2202-3) has the primer flaking off in large chunks. it appears that the pod was not properly cleaned before the primer base was applied. see attached pictures			
Keywords paint flaking		Product D3322-041	
Document		Root Cause	
Closed By Downing, Eric M	Closed Date 05/02/2015	Resolution	

Target Date 16/01/2015	Owner Downing, Eric M	Closed Date 05/02/2015	Closed By Downing, Eric M
Details issue was a lack of cleaning and supplier is aware			

Number	Owner	Target Date	Completed Date
Details	Response		
2	Lavoie, Chantal	16/01/2015	12/11/2014
contact supplier to obtain a corrective action and a root cause. inform supplier of two types of actions that can be taken here at Dart1- send the pod back to them (will need a PMA#)2- Mask off all areas of the pod that is NOT flaking and apply paint stripper ONLY to the alodined / aluminium material to have primer removed. then scuff the entire inside surface of the pod with red scotch brite and reapply the primer as per QSI005 (supplier should be billed for repair work done here @ Dart)		removed all loose paint, feather hard edge of pocket to blend, re-Alodine any and all exposed aluminum. Scotch brite inside of lid and re-prime to ensure a match for primersee attached email	
3	Downing, Eric M	16/01/2015	05/02/2015
reinspect inside finish of pod		rework that was carried out was acceptable and inspected by Pat D on work order	

Target Date	Owner	Closed Date	Closed By
16/01/2015	Smith, Patrick	05/02/2015	Downing, Eric M
Details all actions complete			

Number	Owner	Target Date	Completed Date
Details		Response	